

# Work Order ID 75337

October-21-11 7:56:48 AM

**\*75337\***

Page 1

Item ID: D3212-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Floor Window  
 Start Date: 20/10/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 08/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/21 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3212	C								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut blankas per Dwg D3212 Dwg Rev: <u>B</u> Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA349 and Dwg D3212								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

B11-11-1

6

B11-11-1

SL 11-11-23

SL 11-11-23

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 75337****\*75337\***

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Revision ID:      Stop **\*NS2\***  
Item Name: Floor Window  
Start Date: 20/10/2011      Start Qty: 6.00      **\*6\***      Cust Item ID:  
Required Date: 08/11/2011      Req'd Qty: 6.00      **\*6\***      Customer:  
Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run Start **\*NR1\***  
QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		oik nhl/23		6	8		
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo 1-Deburr if necessary2-Install label as per Dwg D32123- polish abrasion scratches if necessary.. 4-Wrap in plastic wrap after inspection	0.00  0.00							
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

11/11/29 (6)

11 - 11 - 29 (6)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 75337****\*75337\***

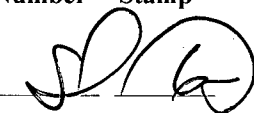
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Item Name: Floor Window  
Start Date: 20/10/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 08/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>210</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

11/11/30 

11/12/11 

CL 11/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 7:56:53 AM

Page 1

Work Order ID: 75337

**\*75337\***

Parent Item: D3212-1

**\*D3212-1\***

Parent Item Name: Floor Window

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-09 JLM  
 IPP Rev: B Water jet/ ecn798 06-05-08 EC  
 IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	No			100	Each	0.0000	0	0			
<b>*D2728-1*</b>									**				
Dart Logo label													
MACRLICS.125		Purchased	No			140	sf	59.2434	0.9745	6.154737			
<b>*MACRLICS 125*</b>									**				
1/8" Polycast II Sheet													

## Location

## Loc Qty

## Loc Code

MAT 117431  
 MAT018 117324  
 MAT019 115338

55.9967  
 55.9967  
 0.2467  
 0.2467  
 3  
 3

117431

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 75337
<b>Description:</b> Floor Window		<b>Part Number:</b> D3212-1
<b>Inspection Dwg:</b> D3212	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	/		H-G	
6.367	+/-0.005	6.367	/			
0.625	+/-0.005	.625	/			
Ø0.156	+0.005/-0.001	.156	/			
R0.25	+/-0.030	.25	/			
8.150	+/-0.005	8.150	/		VERA CNC-02	
3.750	+/-0.005	3.750	/			
0.313	+/-0.010	.313	/			
15.14	+/-0.030	15.141	/			
12.520	+/-0.005	12.520	/			
6.260	+/-0.005	6.260	/			
1.312	+/-0.005	1.312	/			
0.313	+/-0.010	.312	/			
3.750	+/-0.005	3.750	/			
8.150	+/-0.005	8.150	/			
8.462	+/-0.005	8.463	/			
9.09	+/-0.030	9.09	/			

<b>Measured by:</b> JL	<b>Audited by:</b> GML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-11-23	<b>Date:</b> 11/11/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	

.078

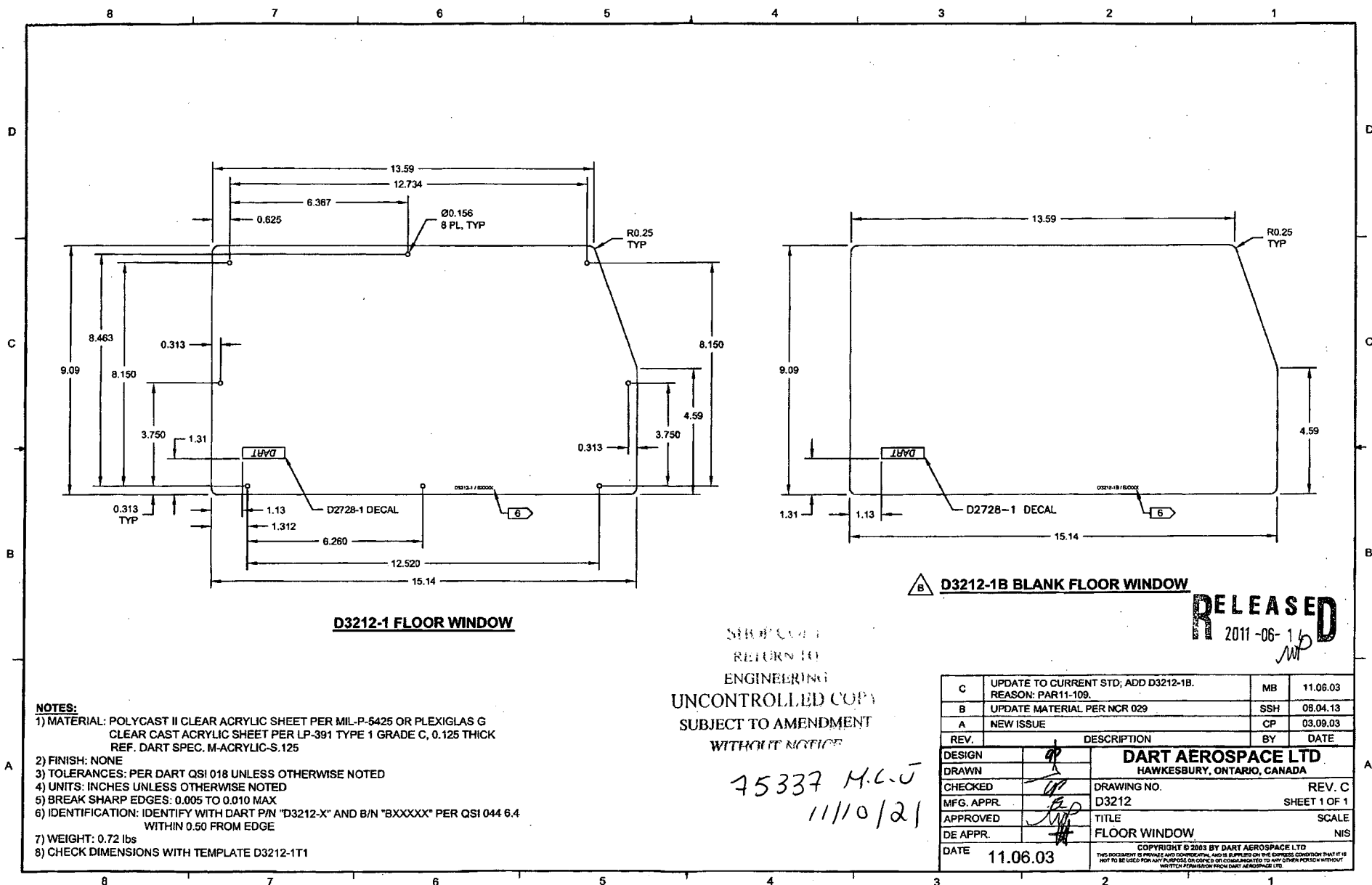
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STANDARD  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

75337 M.C.U  
11/10/21

**D3212-1B BLANK FLOOR WINDOW**

**RELEASED**  
2011-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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